

Split ship July 15

Work Order ID 60162-2



Page 1

Item ID: D4132-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, LH Fwd

Start Date: 6/29/10

Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-6-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4132

A

100



Waterjet

FLOW CNC Waterjet

304.000

FLOW WATER JET

Memo

1-Cut D4132-1F as per Dwg D4132

Dwg Rev: A

Prog Rev:

2-Deburr if necessary

0.00

0.00

0.00

0.00

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

Scrap
10-09-28
Design Change
Deburr = 1 m.p. w/ 06/29 (3x)

10-6-29

(3)

10-6-29

(+3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4132-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>60162</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10.10.06</u>	<u>100</u>	<u>Design changed. PARTS NO LONGER CORRECT</u>	<u>W</u> <u>10/10/07</u> <u>201012</u>	<u>SCRAP 9/10.10.06</u> <u>NEW PARTS MADE</u> <u>TO REV. B</u>	<u>10.10.06</u> <u>10.10.06</u>	<u>S</u> <u>10/10/07</u> <u>01/10/07</u>	<u>W</u> <u>10-10-07</u> <u>01/10/07</u>	<u>B</u> <u>10-10-07</u>

NOTE: Date & initial all entries

Work Order ID 60162

June 28, 2010 11:49:20 AM



Page 2

Item ID: D4132-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, LH Fwd

Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130



Brake NC

Form as per dwg
NC BRAKE

0.00

Memo

0.00

I- Form using DT Die as per Dwg D4132

+9641

10-07-13 one only

PTO

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

9-16-07-14 ①

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: _____
Large Fab


0.00

Memo

0.00

Weld hard surface using DT as per QSI 004 and Dwg D4132

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/07/13	130	had to open hole at .311 to match with the jig	SP	10/07/13	③	 10.7.13 DSI 042		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60162

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Page 3

Item ID: D4132-041

Revision ID:

Item Name: Wearplate, LH Fwd

Start Date: 6/29/10 Start Qty: 2.00

Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 60162

June 28, 2010 11:49:21 AM



Page 4

Item ID: D4132-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, LH Fwd

Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

200



Small Fab

Small Fab

Memo
1- Bond D4132-3 gasket to inner surface of wearplate using a thin layer of 3M
1300/1300L scotch grip adhesive
Batch: _____

0.00

0.00

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60162

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Page 5

Item ID: D4132-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, LH Fwd

Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

mf
10-10-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:49:19 AM

Page 1

Work Order ID: 60162

Parent Item: D4132-041

Parent Item Name: Wearplate, LH Fwd



Start Date: 6/29/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4132-3		Manufactured	No			200	Each	0.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Gasket

M304S18GA		Purchased	No			100	sf	132.8779	1.555	3.273684			
-----------	--	-----------	----	--	--	-----	----	----------	-------	----------	--	--	--



304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT20

132.8779

111743

8.86

112885

28.0179

113062

96

113062

4.665

18 10-6-09

B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 60162
Description: WEARPLATE LH FWD		Part Number: D4132-641
Inspection Dwg: D4132-1 Rev: #		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
300X300	± .010	302X303	✓			
Ø .203	+ .005 - .001	.204	✓			
.415	± .010	.413	✓			
.82	± .030	.823	✓			
2.74	± .030	2.731	✓			
4.65	± .030	4.638	✓			
5.055	± .010	5.054	✓			
5.47	± .030	5.467	✓			
8.05	± .030	8.043	✓			
.375	± .010	.372	✓			
1.92	± .030	1.917	✓			
5.099	± .010	5.099	✓			
9.824	± .010	9.824	✓			
11.92	± .030	11.92	✓			
14.548	± .010	14.549	✓			
19.273	± .010	19.273	✓			
21.92	± .030	21.92	✓			
23.613	± .010	23.613	✓			
27.953	± .010	27.953	✓			
1.10	± .030	1.092	✓			
4.37	± .030	4.361	✓			
11.79	± .030	11.79	✓			
12.04	± .030	12.04	✓			
.050	± .010	.050	✓			

Measured by: KB
Date: 10-6-29

Audited by: J
Date: 10/06/30

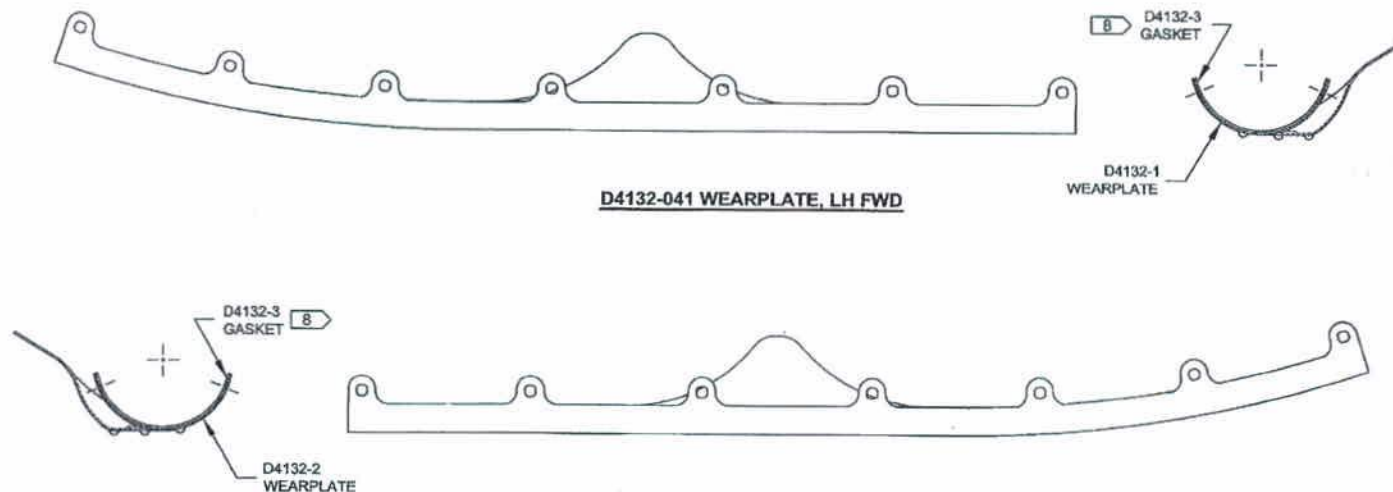
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 68162
8810629

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D4132-041	WEARPLATE, LH FWD
	X	D4132-042	WEARPLATE, RH FWD
1		D4132-1	WEARPLATE
1		D4132-2	WEARPLATE
1		D4132-3	GASKET
AVR	AVR	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



RELEASED
2010-06-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4132-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.1 lbs
- 8) BOND D4132-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

REV.	NEW ISSUE	DESCRIPTION	CP	10.06.15
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.06.15			

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. REV. A
D4132 SHEET 1 OF 6

TITLE SCALE
WEARPLATE, FWD NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

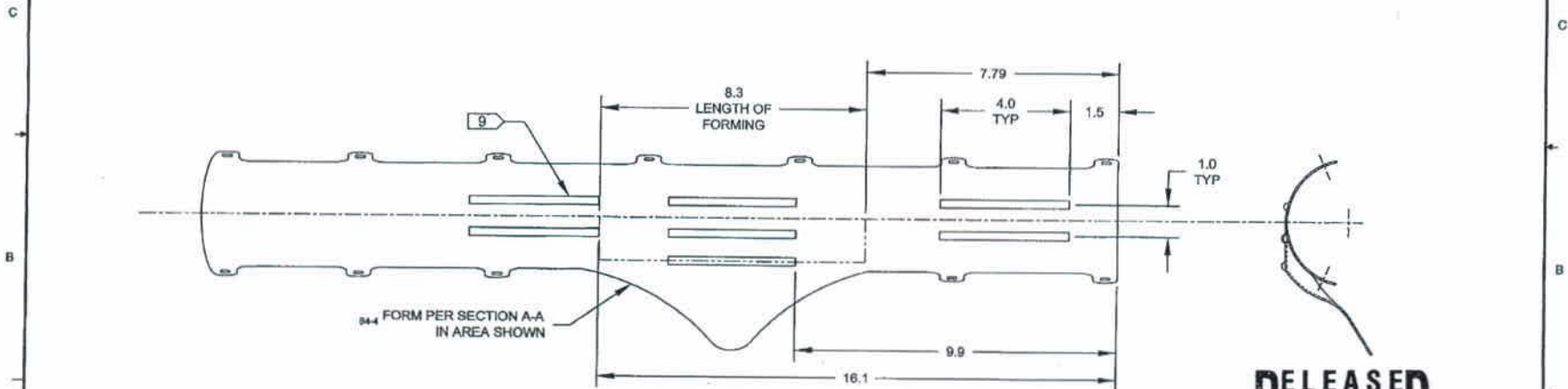
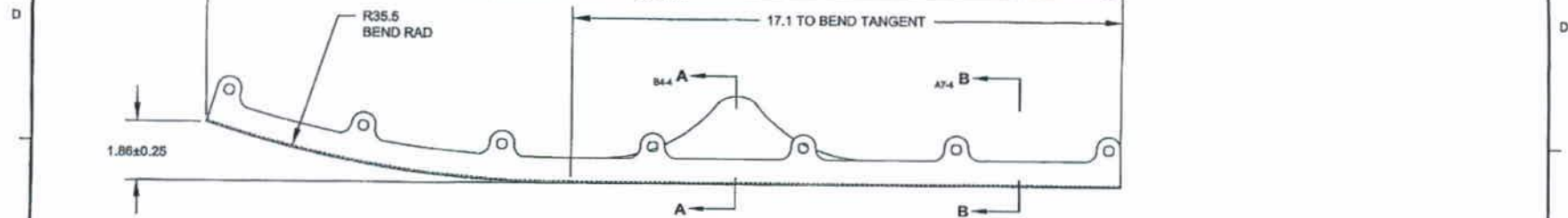
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4132-1 WEARPLATE, LH

RELEASED
2010-06-23
JMP

- NOTES:
- 1) MATERIAL: MAKE FROM D4132-1F
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.8 lbs
 - 8) WELD PER QSI 004
 - 9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 HIGH

who 60462

DESIGN	92	DART AEROSPACE USA, INC	REV. A
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	SHEET 2 OF 6
MFG. APPR.	91	D4132	
APPROVED	91	TITLE	SCALE
DE APPR.	91	WEARPLATE, FWD	NTS
DATE	10.06.15	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

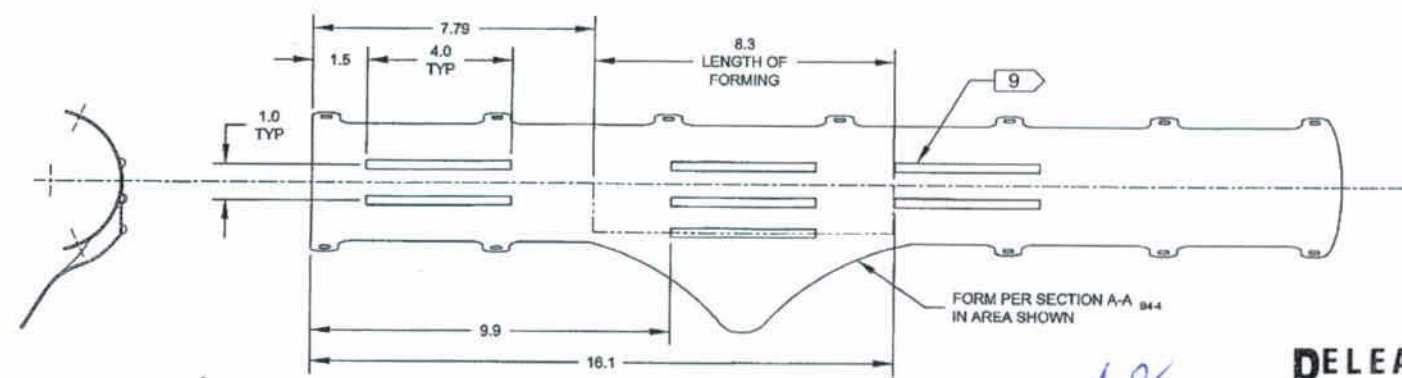
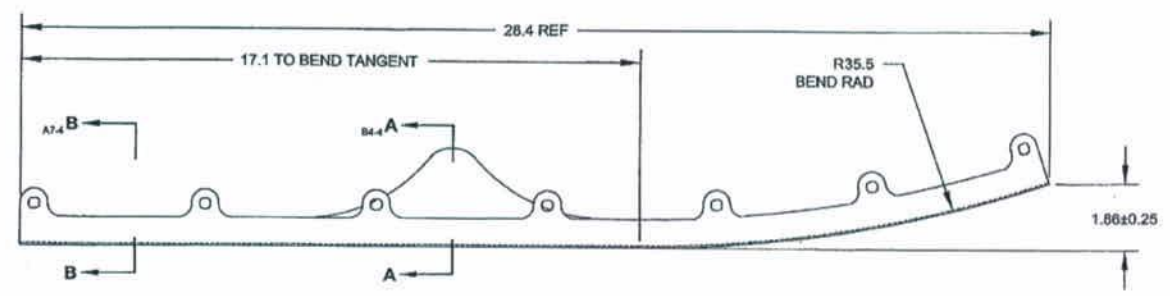
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A



D4132-2 WEARPLATE, RH

- NOTES:**
- 1) MATERIAL: MAKE FROM D4132-1F
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3,5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.8 lbs
 - 8) WELD PER QSI 004
 - 9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 H:GH

WLO 60162

RELEASED
2010-06-23
WJP

DESIGN	92	DART AEROSPACE USA, INC	
DRAWN	92	PORT HADLOCK, WA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D4132	SHEET 3 OF 8
APPROVED	92	TITLE	SCALE
DE APPR.	92	WEARPLATE, FWD	NTS
DATE	10.06.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF UNCLASSIFIED INFORMATION. IT IS NOT TO BE USED FOR ANY PURPOSES OR IN CONNECTION WITH ANY OTHER PROGRAMS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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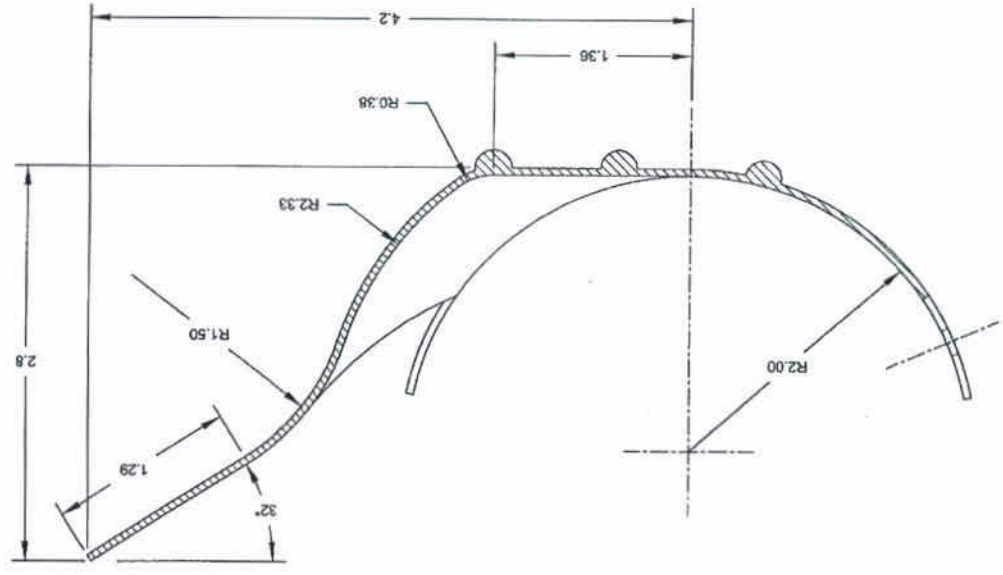
NOTE: Date & initial all entries

DESIGN	DATE	10.06.15
DRAWN	DE APPR.	
CHECKED	APPROVED	
DRAWING NO.	MG. APPR.	
REV. A	D4132	
SHEET 4 OF 6		
SCALE		
WEARPLATE, FWD		
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PORT HADLOCK, WA		

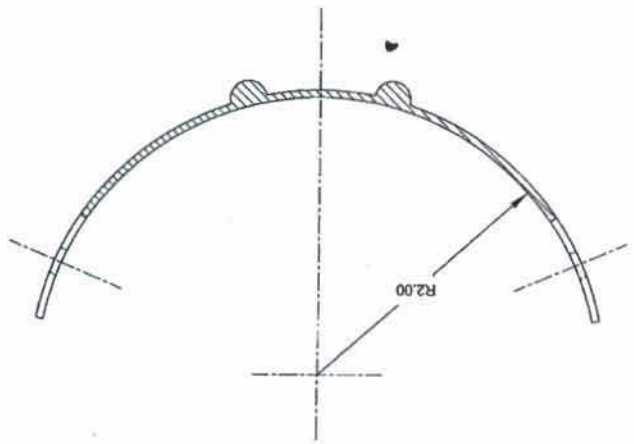
RELEASED
2010-06-23

WLC 60142

SECTION A-A
SCALE 4X



SECTION B-B
SCALE 4X



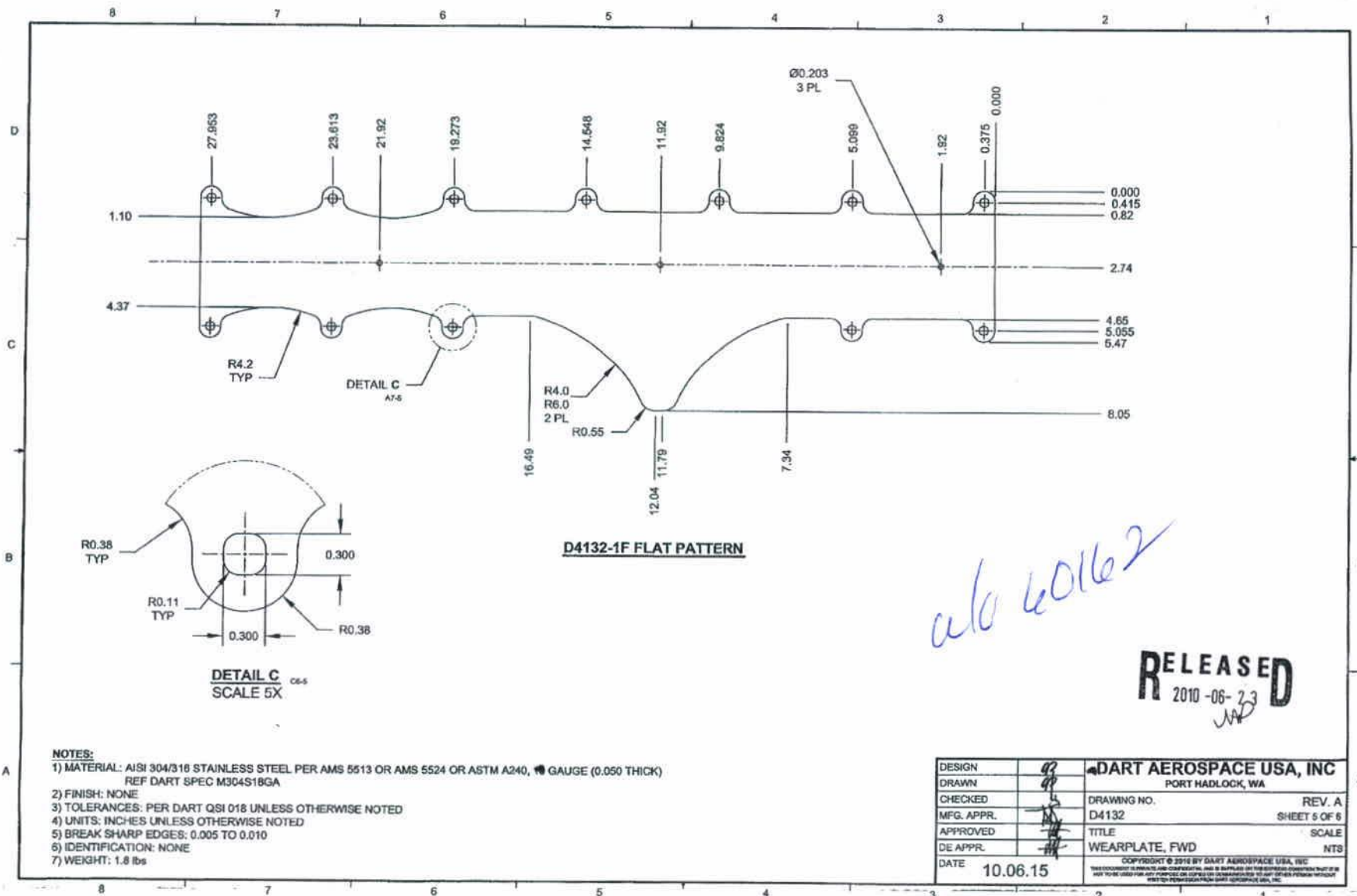
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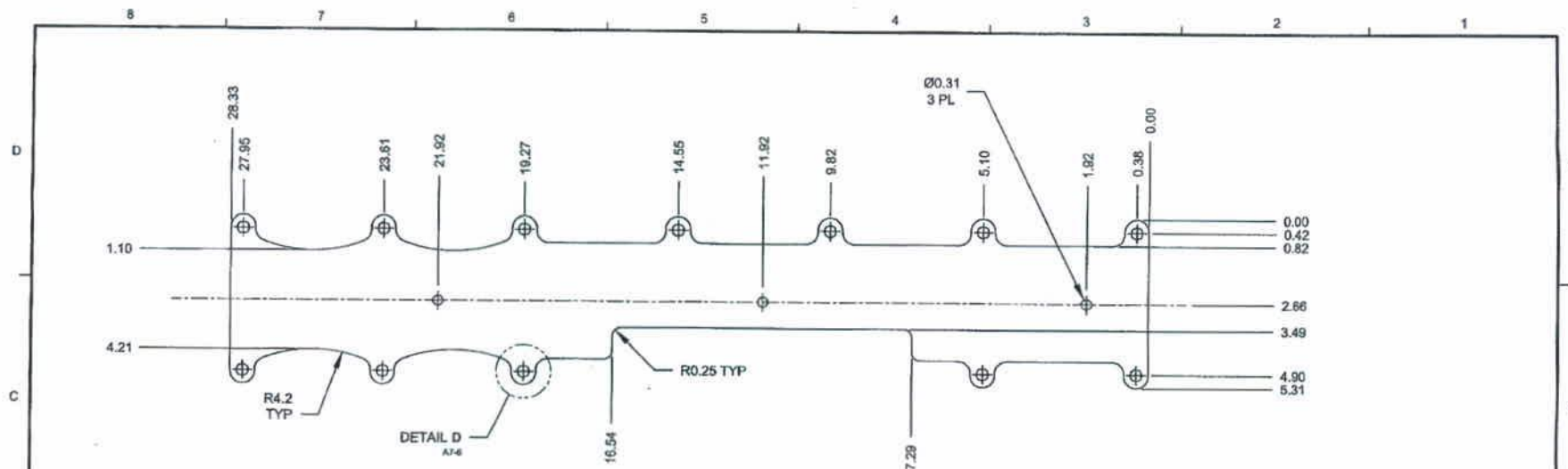
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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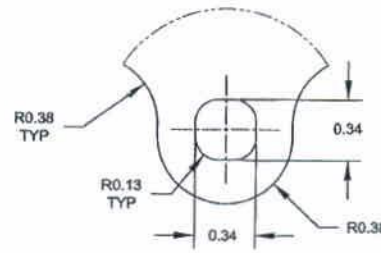
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NOTE: Date & initial all entries



D4132-3 GASKET



DETAIL D
SCALE 5X

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO80-S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.35 lbs

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4132	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, FWD	NTS
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RELEASED
2010-06-23

wb wolk

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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